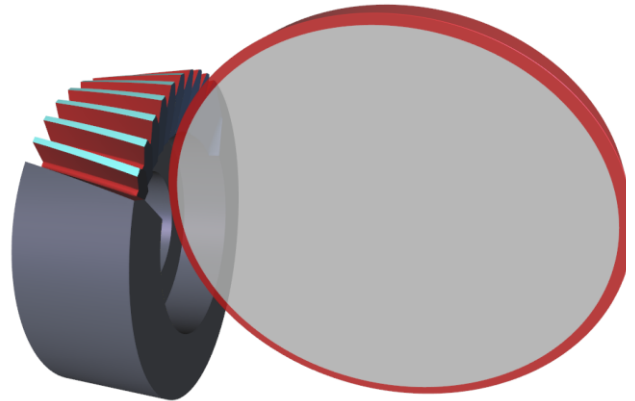







Sharpening Pinion Cutter Ø86.5 Z40 18°

A12-212

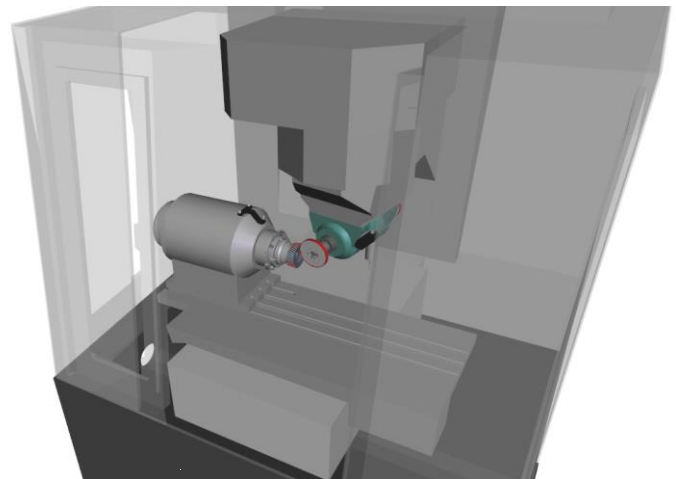
Sharpening concept with CBN wheels, material removal 0.2 mm: 1 pregrinding with coarse wheel, 1 finishing with finer wheel.



1. Cycletime for Resharpening

Workpiece: Ø86.5 Z40 RH Material HSS			
Operations			
	Probe	Front pregrd	Front finish
Feed [mm/Min]	2000	100	250
Power [kW]		1	1
Cutting speed [m/s]		32	32
Used wheels			
		1	2
Grinding time [s]	25	662	313
Total cycle time	16 Min 40		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	1A1 Ø100 B126
2	1A1 Ø100 B76



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGC

Control: Fanuc 31iB 5

Accessories:

Responsible engineer: OP, 16.10.19

Coolant: Synthetic Oil, pressure 6 bar

Software: Qg1

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